

Work Order ID 105748

105748

Page 1

August-16-13 11:40:48 AM

Item ID: D3186-2M

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: SPACEPOD DOOR RH

Start Date: 8/16/13 Start Qty: 1.00

1

Cust Item ID:

Required Date: 9/13/13 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: ML5 Date: 13-08-16 Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3186	Rev E
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100		0.00
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100

PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 20980 *

Description: D3186-2MDoor

Supplier: Delastek *

Conformity Certificate and Process sheet required

Ship 3 Items from Previous steps

CZ 13/08/19 ①

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Memo

0.00

Packaging

Ensure a copy of certification of conformity and process sheet from Delastek is attached.

13/10/20 ①

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data <input type="checkbox"/>									
Equip/Tooling <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Material <input type="checkbox"/>									
Setup <input type="checkbox"/>									
Other <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions
---	---	---

<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Work Order ID 105748

105748

Page 2

August-16-13 11:40:48 AM

Item ID: D3186-2M

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: SPACEPOD DOOR RH

Stop *NS2*

Start Date: 8/16/13 Start Qty: 1.00

1

Cust Item ID:

Required Date: 9/13/13 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120 QC6- Inspect dimensions to drawing

0.00

120

QC

Memo

0.00

Quality Control

Check for void spot and pins.

130

Identify as per dwg & Stock Location: CA

0.00

130

Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

DAS
27
0.00

14/11/15

4-11-05

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: AW Date: 14/12/11QA Closed: SL Date: 14/12/10

Work Order: <u>105748</u> Part No. <u>D3186-2M</u> NCR No. <u>14-4446</u> <u>SUPPLIER NCR #14-4456</u>				DISPOSITION Rework <input checked="" type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input checked="" type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input checked="" type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
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Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	14-11-03	120	x1	Primer has air pockets under weath in corners (from supplier) R.C. Primer too thick / improperly scaffolded before priming suppli issue	A.P. 14.11.03	Remove any loose primer. Sand/feather edges + re-prime	SHD 14/11/05	14-11-05	DAS 16 9-89 14/11/05
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier <input checked="" type="checkbox"/>									
Training									
Unapproved									

FAULT CATEGORY											
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input checked="" type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other		

Picklist Print

August-16-13 11:40:51 AM

Page 1

Work Order ID: 105748

105748

Parent Item: D3186-2M

D3186-2M

Parent Item Name: SPACEPOD DOOR RH

Start Date: 8/16/13

Required Date: 9/13/13

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 06-12-04 ec
IPP rev D rv D dwg 07.03.07 ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3186-2P		Purchased	No			110	Each	1.0000	1	1			
D3186-2P									**			14-11-03	
Spacepod Door													

Location

Loc Qty

Loc Code

CA

1

95612

1

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

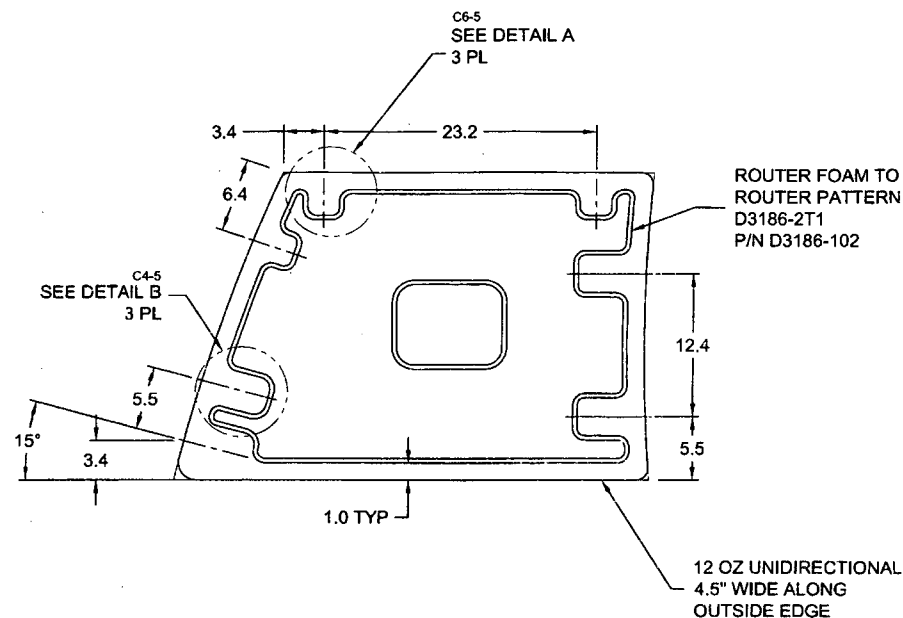
Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear	General	Other
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabeled
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized
		<input type="checkbox"/> Over/Under tolerance
		<input type="checkbox"/> Part Incorrect
		<input type="checkbox"/> Part Lost/Missing
		<input type="checkbox"/> Part Moved
		<input type="checkbox"/> Positioned Wrong
		<input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced
		<input type="checkbox"/> Temperature/Cure
		<input type="checkbox"/> Weld
		<input type="checkbox"/> Wrong Stock Pulled
		<input type="checkbox"/> Other

9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35-45% BY WEIGHT)
PEEL PLY



105748 MC^c
13-08-16

1) MATERIAL:

RESIN = EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
FOAM = 3/8". A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
FIBRE = 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
LAMINATE PER DART QSI 006 4.0
LAMINATION SCHEDULE PER THIS DRAWING

2) FINISH: FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: 7.0 lbs

8) USE MOLD DT8006 FOR DOOR LAYUP

D3186-2M SPACEPOD DOOR AS MOLDED

RELEASED
2009-08-09

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV.
MFG. APPR.	<i>[Signature]</i>	D3186	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SPACEPOD DOOR	NT
DATE 09.07.08		COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE LTD. NO COPIES OR REPRODUCTIONS OF ANY KIND ARE TO BE MADE OR USED FOR ANY PURPOSE OR COPIES OR REPRODUCTIONS TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	



DELASTEK Inc.
2699 5e Avenue
Local 14,
Grand-Mère, Québec G9T 2P7
Canada
Tel.: (819) 533-5788
Fax: (819) 533-3494

PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice No.	49592
Customer No.	DART US

Bill To

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Telephone : 613-632-5200
Contact : Linda Lacelle

Ship To

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Telephone : 613-632-5200
Contact : Linda Lacelle

Ship Date	Order Date	Our SO #	Ordered by	Your PO#	Terms
24-10-2013	11-09-2013	23834	Chantal Lavoie	20980	Net 30 days USA
Ship Via	F.O.B.	Salesperson	GST/PST		
FEDEX P1 Collect	Point de départ	Mathieu Doucet, ext.690			
Order Qty	B.O. Qty	Current Ship.	Item number	Description	
1	0	1	DKC134-0071	Line 1 N° D3188-2M, Spacepod Body RH Dwg. D3188 Rév.: F B105755 Serial # 55561	U of M: Chaque Lot # 55561
1	0	1	DKC134-0060	Line 2 N° D3186-2M Spacepod Door RH Dwg. D3186 Rév.: E B105748 Serial # 55560	U of M: Chaque Lot # 55560

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

Accepted by:

Mathieu Doucet
Quality department



AQ-357

☐ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Date: Lundi, 2013-09-16 13:45:16
 Utilisateur: Mario Chantal

Feuille de Procédé

4 / ASAP

 Client : DART US DART AEROSPACE
 Numéro Job : 55560
 Numéro : 3769
 Numéro B.A. :
 Cette fois : 2013-09-16 No. :
 Prsht Rev. : NC
 Prem. fois : - -
 Job précédente : 55559

 Nom Dessin : SPACEPOD DOOR RH
 Numéro Article : DKC134-0060
 Numéro Dessin : -
 Projet Numéro : DK-362
 Révision dessin :
 Matériel : 7781 & 411-350
 Date Dûe : 2013-09-16

Qté: 1 Ud UNITE

 Écrit par :
 Vérifié & Approuvé par :
 Commentaires : N° de dessin: D3186-2M rev. E

E.O.: N/A

 Feuille de Procédé Rév.: 03 AMB0349 remplacé par
 AMB0511 (réf. RFC #226)

Formulaire d'inspection: N/A

Produit additionnel

Numéro Job:



# Séq.:	Machine ou	Description :
1.0	AAC1616	N° 83634, Frekote Loctite Wolo
Comment	Qty.: 0.050 UNITE(s)/Unit Total : 0.050 UNITE(s)	N° de Lot: N/A

2.0	PRÉPARATION	Préparation du moule
-----	-------------	----------------------



Comment Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Faire la préparation du moule N° DT 8006 selon IG 0009.

Date: 17/09/13 Sceau:



3.0	AAC1885	Tissu à délaminer Release ply B
Comment	Qty.: 3.28 VERGE(s)/Unit Total : 3.28 VERGE(s)	# de Lot: N/A


4.0	AAC1887	Wrighton 5200 Bleu P3
Comment	Qty.: 3.59 VERGE(s)/Unit Total : 3.59 VERGE(s)	# de Lot: N/A



5.0	AC0885	Feutre de drainage N° Airweave N 10
Comment	Qty.: 3.00 VERGE(s)/Unit Total : 3.00 VERGE(s)	

Date: Lundi, 2013-09-16 13:45:16

Utilisateur: Mario Chantal

Feuille de Procédé

Client:	DART US DART AEROSPACE	Nom Dessin:	SPACEPOD DOOR RH
Numéro Job:	55560	Numéro	DKC134-0060
Numéro Job:			

# Séq.:	Machine ou Opération:	Description :
6.0	AC0943	Stretchlon 200 poche à vide Vert
Comment	Qty.: 3.00 VERGE(s)/Unit Total : 3.00 VERGE(s)	
7.0	AMB0214	9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish
Comment	Qty.: 4.50 VERGE(s)/Unit Total : 4.50 VERGE(s) 9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish	N° de Lot: 1-41291-1
8.0	AC0886	Ruban à gommer jaune #: T/AT-200Y
Comment	Qty.: 2.2500 ROULEAU(s)/Unit Total : 2.2500 ROULEAU(s)	
9.0	AMB0511	N° TG-13-U, Fiberglass 13 oz
Comment	Qty.: 1.00 VERGE(s)/Unit Total : 1.00 VERGE(s) N° TG-13-U, Fiberglass 13 oz	N° de Lot: 1-36302-1
10.0	PREP-GENERAL	Préparation du matériel
		



Comment Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Tailler le matériel selon les différents patrons de découpe.

Appliquer le ruban jaune tout le tour du stretchlon 200 en laissant le papier sur le coté non en contact avec le sac à vide.


Afin d'accélérer le processus de taillage, tailler les plis de 9.7 oz. tous en même temps en les superposants les uns sur les autres.

Date: 17.09.13 Sceau: Sk 4485 LM 4482

11.0	AMB0286	Catalyst N° DDM-9
Comment	Qty.: 0.0080 GALLON(s)/Unit Total : 0.0080 GALLON(s) Catalyst N° DDM-9	N° de Lot: 1-27829-1
12.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.
Comment	Qty.: 0.500 LITRE(s)/Unit Total : 0.500 LITRE(s) Résine (411B7530) 411-350 promo. 75min.	N° de Lot: 1-42176-1
13.0	PREP-GENERAL	Préparation du matériel
		

Comment Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Faire la préparation de la résine selon les quantités requises, mix ratio 1.5% catalyst par quantité de résine.

Date: 17/09/13 Sceau: 4460 R.L. 

Date: Lundi, 2013-09-16 13:45:16
Utilisateur: Mario Chantal

Feuille de Procédé

Client: DART US DART AEROSPACE
Numéro Job: 55560

Nom Dessin: SPACEPOD DOOR RH
Numéro DKC134-0060

Numéro Job:



Séq.:

Machine ou Opération:

Description :

14.0

LAMINAGE

Faire le laminage



Comment Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

À l'aide d'un rouleau de 2" dia. appliquer une couche de résine sur le moule et ensuite imbiber un pli de tissu 9.7 oz.

Date: 17/09/13 Sceau: 4460 R.L.



15.0

BAGGING

Faire le bagging sur la pièce



Comment Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire la poche à vide selon IG 0012.

Laisser sécher pendant 4 heures minimum.

Heure début Curing: 3:45

Heure Fin Curing:

Date: 17/09/13 Sceau: 4460 R.L.



16.0

AMB0286

Catalyst N° DDM-9

Comment Qty.: 0.0120 GALLON(s)/Unit Total : 0.0120 GALLON(s)
Catalyst N° DDM-9 N° de Lot: 1-27829-1

17.0

AMB0212

Résine (411B7530) 411-350 promo. 75min.

Comment Qty.: 0.300 LITRE(s)/Unit Total : 0.300 LITRE(s)

Résine (411B7530) 411-350 promo. 75min

N° de Lot: 1-42176-1

18.0

PREP-GENERAL

Préparation du matériel



Comment Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Faire la préparation de la résine selon les quantités requises, mix ratio 1.5% catalyst par quantité de résine et imbiber toutes les surfaces du Foam Core selon IG0105.

Date: 19-09-13 Sceau: 4460 R.L.

19.0

DKC134-0057

Foam Core N° D3186-102 (Porte D3186-2)

Comment Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)

Foam Core N° D3186-102 (Porte D3186-2)

N° de Job:

55632

Date: Lundi, 2013-09-16 13:45:16
Utilisateur: Mario Chantal

Feuille de Procédé

Client: DART US DART AEROSPACE
Numéro Job: 55560

Nom Dessin: SPACEPOD DOOR RH
Numéro DKC134-0060

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
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20.0	AAC1611	Polybond B46F
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Comment Qty.: 0.090 KIT(s)/Unit Total : 0.090 KIT(s)
Polybond B46F N° de Lot: 1-38189-1

21.0	ASSEMBLAGE	Assemblage mécanique
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Comment Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Retirez le bagging.

Pour aider au positionnement de 13 oz., positionner le gabarit de trimage dans le moule et tracer son contour sur le 9 oz. Retirez le gabarit de trimage.

Positionner le foam core à l'aide du gabarit prévu à cet effet et tracer le contour sur le 9 oz. (Vous devriez maintenant avoir 2 contours de tracé sur le 9 oz.)

Appliquer une couche de Polybond B64F à l'endos du Foam Core N° DKC134-0057 et positionner le foam Core sur le moule selon le dessin, et selon les lignes de positionnement prévues à cet effet.

Date: 21-09-13 Sceau: Y460 RL

22.0	BAGGING	Faire le bagging sur la pièce
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Comment Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire la poche à vide selon IG 0012.

Retirer le bagging avant la fin de la polymérisation (entre 1h et 1h30) afin d'enlever le surplus de Polybond.

Heure début Curing: 10:20 Heure Fin Curing: 8:00

Date: 21-09-13 sceau: RL Y460 RL

23.0	AMB0286	Catalyst N° DDM-9
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Comment Qty.: 0.0400 GALLON(s)/Unit Total : 0.0400 GALLON(s)
Catalyst N° DDM-9 N° de Lot: 1-42176-1

24.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.
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Comment Qty.: 1.000 LITRE(s)/Unit Total : 1.000 LITRE(s)
Résine (411B7530) 411-350 promo. 75min N° de Lot: 127824-1

Date: Lundi, 2013-09-16 13:45:16
Utilisateur: Mario Chantal

Feuille de Procédé

Client: DART US DART AEROSPACE	Nom Dessin: SPACEPOD DOOR RH	
Numéro Job: 55560	Numéro DKC134-0060	
Numéro Job: 		
# Séq.:	Machine ou Opération:	Description :
25.0	PREP-GENERAL	Préparation du matériel
 		
Comment Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs Faire la préparation de la résine selon les quantités requises, mix ratio 1.5% catalyst par quantité de résine. Date: <u>27/09/13</u> Sceau: <u>4460 R.L.</u> 		
26.0	LAMINAGE	Faire le laminage
 		
Comment Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs Faire le laminage d'un pli de 9.7 oz. Faire le laminage d'un pli de 13 oz. tout le tour de la porte. Faire le laminage d'un pli de 9.7 oz. Date: <u>27/09/13</u> Sceau: <u>4460 R.L.</u> 		
27.0	BAGGING	Faire le bagging sur la pièce
 		
Comment Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs Faire la poche à vide selon IG 0012. Laissez Sécher 4 heures minimum Heure début Curing: <u>3:00</u> Heure Fin Curing: <u>8:00</u> Date: <u>27/09/13</u> Sceau: <u>4460 R.L.</u> 		
28.0	DÉMOULAGE	Démoulage de la pièce
 		
Comment Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs Démouler la pièce en faisant bien attention aux coins & Edges. Sabler la surfaces de la pièce qui était en contact avec le moule afin d'éliminer le fini lisse de celui-ci. Date: <u>30-09-13</u> Sceau: <u>4460 R.L.</u>		

Date: Lundi, 2013-09-16 13:45:16
Utilisateur: Mario Chantal

Feuille de Procédé

Client: DART US DART AEROSPACE
Numéro Job: 55560

Nom Dessin: SPACEPOD DOOR RH
Numéro DKC134-0060

Numéro Job:



Séq.:

Machine ou Opération:

Description :

29.0

TRIMAGE

Trimage



Comment Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Trimer le contour de la pièce à l'aide du gabarit de trimage prévu à cet effet.

Date: 30-09-13 Sceau: 4460RL

30.0

AAC1021

Dupont Primer N° 7704S

Comment Qty.: 0.1400 UNITE(s)/Unit Total : 0.1400 UNITE(s)
Dupont Primer N° 7704S N° de Lot: 1-42451-1

31.0

AAC1101

N° 7775S, Dupont Activator - Reducer Chromabase

Comment Qty.: 0.0283 UNITE(s)/Unit Total : 0.0283 UNITE(s)
N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: 1-41909-3

32.0


PRIMER

Application primer



Comment Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Appliquer une couche de primer selon IS 0008.

Date: 2/10/13 Sceau:  # de fiche de mélange: 6475

33.0

AAC1492

N° P-15-3, Adtech Micro Ultra Filler

Comment Qty.: 0.010 GALLON(s)/Unit Total : 0.010 GALLON(s)
N° P-15-3, Adtech Micro Ultra Filler N° de Lot: _____

34.0

FINITION

Finition Générale



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire les réparations de finition si nécessaire à l'aide du "Filler" P15-3.

Faire un léger sablage (Grit 220) de toutes les surfaces.

Date: 04-10-13 sceau: 4460RL

35.0

AAC1021










Dupont Primer N° 7704S

Comment Qty.: 0.1400 UNITE(s)/Unit Total : 0.1400 UNITE(s)
Dupont Primer N° 7704S N° de Lot: 1-37302-1

Date: Lundi, 2013-09-16 13:45:16

Utilisateur: Mario Chantal

Feuille de Procédé

Client: DART US DART AEROSPACE	Nom Dessin: SPACEPOD DOOR RH	
Numéro Job: 55560	Numéro DKC134-0060	
Numéro Job: 		
# Séq.:	Machine ou Opération:	Description :
36.0	AAC1101	N° 7775S, Dupont Activator - Reducer Chromabase
Comment Qty.: 0.0300 UNITE(s)/Unit Total : 0.0300 UNITE(s) N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: <u>6-40542-1</u>		
37.0	PRIMER	Application primer
 		
Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Appliquer une couche de primer selon IG 0008. Date: <u>10-10-13</u> Sceau:  # de Fiche de mélange: <u>6480</u>		
38.0	INSPEC FINAL	Inspection finale
 		
Comment Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs Faire l'inspection finale par la qualité selon le dessin. Date: <u>11oct-13</u> Sceau: 		
39.0	EMBAL / ENTREPO	Emballage & Entreposage
 		
Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Emballer et entreposer selon IG 0057. Date: <u>11-10-13</u> Sceau: <u>4451Sm</u>		